

[We Claim:

Sub A1
1. A print-receptive, pill-resistant, knitted fabric, said fabric knitted from yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater than about 4 grams/denier, wherein said knitted fabric has a pilling resistance value of greater than about 3.

2. The knitted fabric of claim 1, wherein said knitted fabric is a double-knit fabric having a front side and a back side, the front side being formed from said high-tenacity, staple synthetic fiber and the back side being substantially formed from cellulosic yarn, said cellulosic yarn being selected from the group consisting of cotton and synthetic cellulosic fibers.

a
3. The knitted fabric of claim 1, wherein the back side of said fabric is substantially 100% spun cotton fiber.

a
4. The knitted fabric of claim 1, wherein the front side and back side of said fabric are a single jersey knit construction.

a
5. The knitted fabric of claim 1, further including a tie yarn between the ^{front} face and back of said fabric.

6. The knitted fabric of claim 1, wherein the high-tenacity, staple synthetic fiber has a tenacity of about 6 grams/denier.

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7. A print-receptive, pill-resistant, knitted fabric, said fabric knitted from yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater than about 4 grams/denier, wherein said knitted fabric has a pilling resistance value of greater than about 3, and said high-tenacity, staple synthetic fiber is selected from the group consisting of air jet spun polyester; nylon; acrylic; and polypropylene.

8. The knitted fabric of claim 7, wherein said high-tenacity, staple synthetic fiber is polyester.

9. The knitted fabric of claim 7, wherein said high-tenacity, staple synthetic fiber has a denier of less than about 1.5.

10. The knitted fabric of claim 7, wherein said high-tenacity, staple synthetic fiber has a denier of about 1.

11. The knitted fabric of claim 7, wherein the staple length of said high-tenacity, synthetic fiber is about 1.5 inches.

12. The knitted fabric of claim 11, wherein the staple length of said high-tenacity, synthetic fiber is variable up to about 1.5 inches.

13. A print-receptive, pill-resistant, knitted fabric, said fabric knitted from yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater than about 4 grams/denier, wherein said knitted fabric has a pilling resistance value of greater than about 3, and said high-tenacity, staple synthetic fiber is selected from the group consisting of air jet spun polyester; nylon; acrylic; and polypropylene, and wherein said knitted fabric is a double-knit fabric having a front side and a back side, the front side being formed from said high-tenacity, staple synthetic fiber and the back side being substantially formed from cellulosic yarn, said cellulosic yarn being selected from the group consisting of cotton and synthetic cellulosic fibers.

14. The knitted fabric of claim 13, wherein the back side of said fabric is substantially 100% spun cotton fiber.

15. The knitted fabric of claim 13, wherein the front side and back side of said fabric are a single jersey knit construction.

16. The knitted fabric of claim 13, further including a tie yarn between the front face and back of said fabric.

17. ¹⁰ The knitted fabric of claim 13, ⁶ wherein the high-tenacity, staple synthetic fiber has a tenacity of about 6 grams/denier.

18. ¹¹ The knitted fabric of claim 13, ⁶ wherein said high-tenacity, staple synthetic
5 fiber is polyester.

19. ¹² The knitted fabric of claim 13, ⁶ wherein said high-tenacity, staple synthetic fiber has a denier of less than about 1.5.

20. ¹³ The knitted fabric of claim 19, ¹² wherein said high-tenacity, staple synthetic fiber has a denier of about 1.

21. ¹⁴ The knitted fabric of claim 19, ⁶ wherein the staple length of said high-tenacity, synthetic fiber is about 1.5 inches.

22. ¹⁵ The knitted fabric of claim 21, ¹⁴ wherein the staple length of said high-tenacity, synthetic fiber is variable up to about 1.5 inches.

23. A printed, pill-resistant, article of apparel, said article of apparel knitted from yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater than about 4 grams/denier, wherein said article of apparel has a pilling resistance value of greater than about 3.

24. A printed, pill-resistant, article of apparel, said article of apparel knitted from yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater than about 4 grams/denier, wherein said article of apparel has a pilling resistance value of greater than about 3, and said high-tenacity, staple synthetic fiber is selected from the group consisting of air jet spun polyester; nylon; acrylic; and polypropylene.

25. A printed, pill-resistant, article of apparel, said article of apparel knitted from yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater than about 4 grams/denier, wherein said article of apparel has a pilling resistance value of greater than about 3, and said high-tenacity, staple synthetic fiber is selected

from the group consisting of air jet spun polyester; nylon; acrylic; and polypropylene, and wherein said article of apparel is formed from a double-knit fabric having a front side and a back side, the front side being formed from said high-tenacity, staple synthetic fiber and the back side being substantially formed from cellulosic yarn, said cellulosic
5 yarn being selected from the group consisting of cotton and synthetic cellulosic fibers.

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